

Date: Wednesday, 22/10/2008 1:31:51 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 42820		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 22/10/2008 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 42351	Material	:
Written By	:	Due Date	: 04/11/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>JLD 08.10.22</u>		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.1113 sf(s)/Unit Total : 4.4520 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: ~~4522~~ HB 8-10-07 109657

2.0	WATER JET	FLOW WATER JET
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(PD)

Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: CProg Rev: CHB 8-10-07

(HB)

(40)  
HB 8-10-07

2-Deburr if necessary

HB 8-10-07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-10-07

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8 08/10/28 counter (40)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

S/S 08/10/28

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3537-1 PAR #: N/A Fault Category: Prod - sm / ned. NCR: Yes No DQA: A Date: 08.11.10  
Resolution: other Disp: Re-classify QA: N/C Closed: A Date: 08/11/11

NCR: <u>42820</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/01/23	# 2.6	During inspection it was found that the operator used mild steel instead of Stainless Steel. <u>QTY 4</u>	<u>[Signature]</u> 08/11/12	<del>D2648</del> use for D26483 and replace on 4 this work order	<u>B</u> 8-10-23	<u>S</u> 02/01/23	<u>[Signature]</u> 08/11/12	<u>S</u> 08/10/23
		R.C. water jet operator got confused with other w/o's for mild steel.	<u>[Signature]</u> 08/11/12			<u>S</u> 02/01/23	<u>[Signature]</u> 08/11/12	<u>S</u> 08/10/23

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 1:31:51 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 42820

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat M107213 x 21, M107303 x 19  
1-Weld as per Dwg D3537 using Jig DT 8210  
2-Remove any weld that penetrated through Wearpad if necessary

EL 8-11-5 (740)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/11/05 (40) counter

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/05 (40) counter

9.0

POWDER COATING

POWDER COATING



M 106 442



(40X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30  
320 OF  
4:00

M-1 08/11/05

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/11/06 (40)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

FL 08/11/06 (40)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06

Job Completion



MF 08-11-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

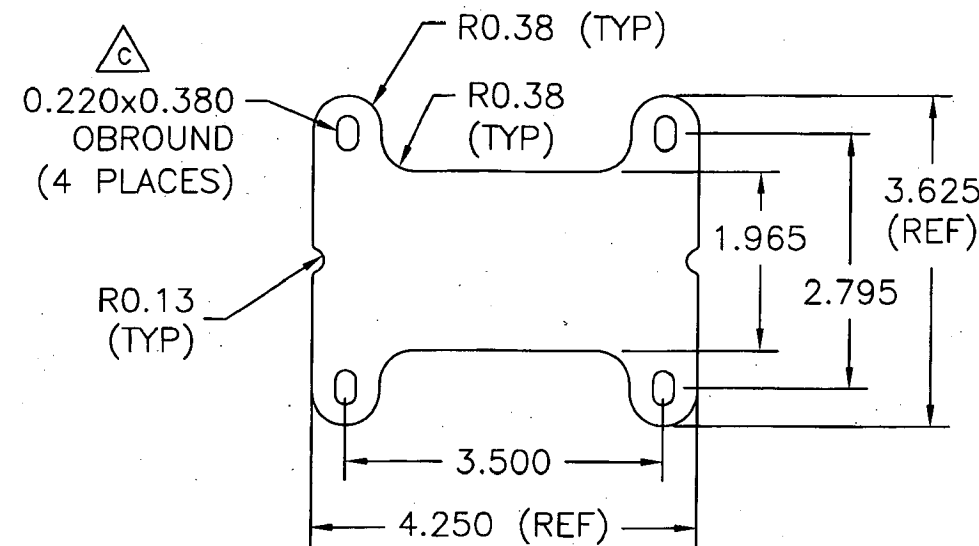
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

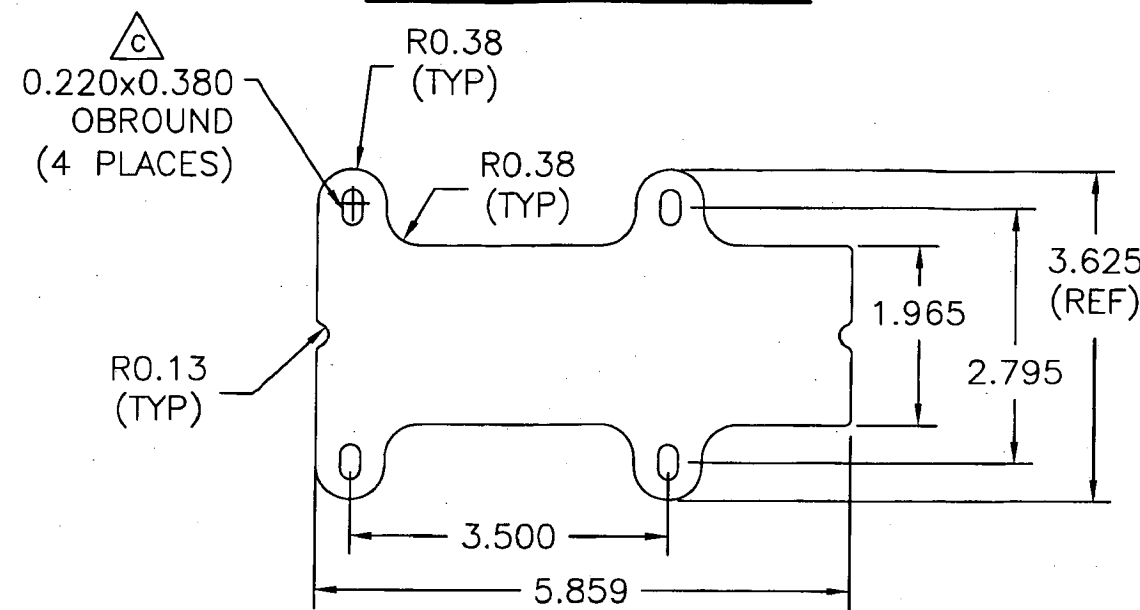
**NOTE:** Date & initial all entries



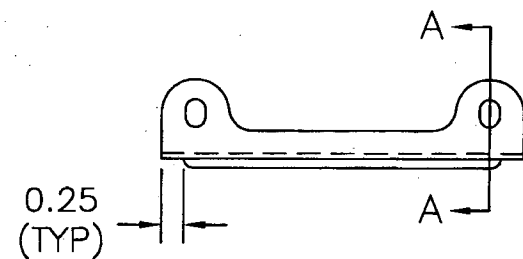
### D3537-1F FLAT PATTERN



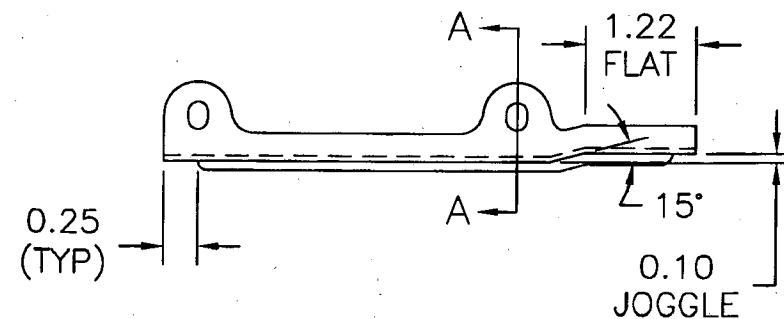
### D3537-3F FLAT PATTERN



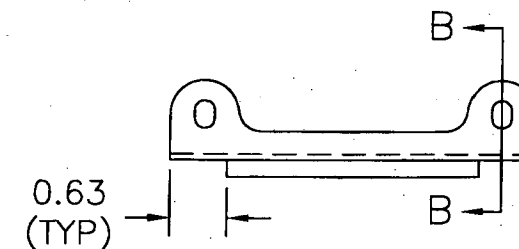
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



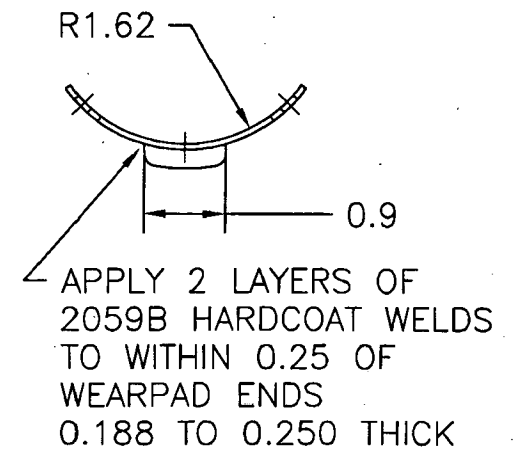
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



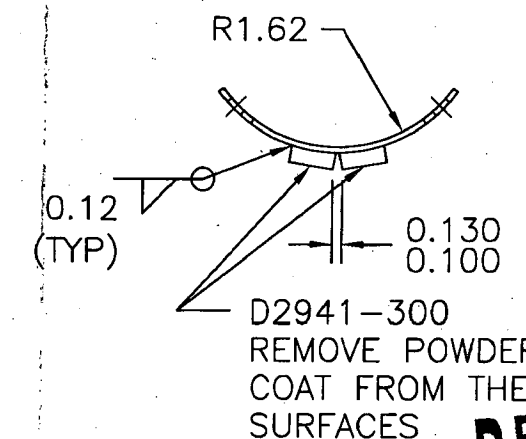
### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

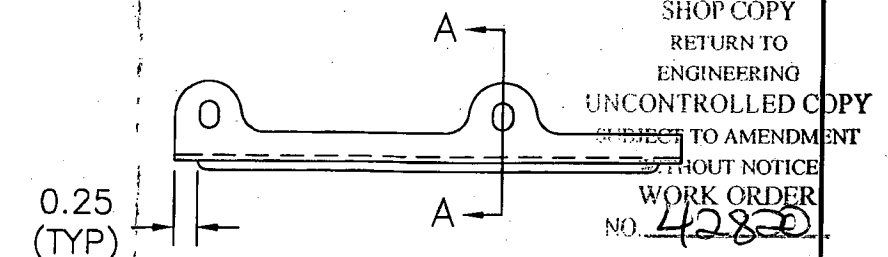
### SECTION A-A



### SECTION B-B



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
		DART AEROSPACE USA, INC. PORT HADLOCK, WA
		DRAWING NO. D3537
		REV. C SHEET 1 OF 1
		SCALE 1:2

